

Work Order ID 165300 -1

Monday, August 21, 2017 10:19:53 AM

165300

Page 1

Item ID: D3591-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bushing

Stop *NS2*

Start Date: 8/21/2017 Start Qty: 10.00

Required Date: 8/21/2017 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3591	Rev B

100

0.19

100

Hardinge

CONVENTIONAL LATHE

Memo

0.39

Hardinge CNC Lathe Small

1-Turn as per dwg D3591 (Ream extrusion if nessasary to obtain ID tolerance per QSI 18)

2-Deburr

DAS
23
9-89

17/8/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.10

Quality Control

DAS
23
9-89

17/8/21

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.20

Quality Control

DAS
38
9-89

AUG 21 2017

Work Order ID 165300***165300***

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Monday, August 21, 2017 10:19:53 AM

Item ID: D3591-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bushing
Start Date: 8/21/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/21/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : FP001	0.00 0.10 <i>ppp 164577</i>				<i>1</i>	DAS 28 9-89	AUG 2 1 2017	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00				<i>Rexia</i>	DAS 21 9-89	AUG 2 3 2017 AUG 2 1 2017	

Picklist Print

Page 1

Monday, August 21, 2017 10:19:51 AM

Work Order ID: 165300

165300

Parent Item: D3591-1

D3591-1

Parent Item Name: Bushing

Start Date: 8/21/2017

Required Date: 8/21/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 07.02.01 new issue EC
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased			No	100	f	67.9088	0.35	3.684211			

M304TR0 500W 035

**

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

GA

67.908796

m137086

12.843477

m137199

2.300579

m137286

0.02674

m137415

26.418

m137623

1.55

m137834

24.77

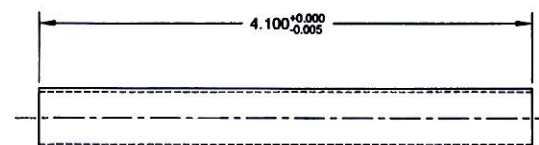
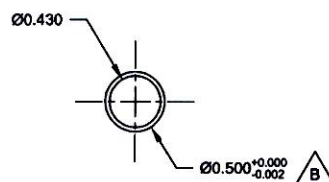
~~0.353~~ 0.353

DAS
23
9-89

17/8/21

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 165300 MCT
120PR1



D3591-1 BUSHING

RELEASED
08-09-05/11

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TR0.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)		AJS	08.08.25
A	NEW ISSUE		PH	07.01.16
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	DRAWING NO.	REV. B	
CHECKED		D3591	SHEET 1 OF 1	
MFG. APPR.		TITLE	SCALE	
APPROVED		BUSHING	NTS	
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	08.08.25			